

Work Order ID 57811

Thursday, April 15, 2010 3:08:05 PM



Page 2

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 4/15/2010

Start Qty: 24.00



Cust Item ID:

Required Date: 4/30/2010

Req'd Qty: 24.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

af 10.4.18

Memo

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

88 10/04/19

Memo

0.00

*24**0*

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=) Jd 10/04/20

Memo

0.00



*24**0*




Work Order ID 57811

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Page 3

Item ID: D3910-3	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Crosstube Lug				
Start Date: 4/15/2010	Start Qty: 24.00		Cust Item ID:	
Required Date: 4/30/2010	Req'd Qty: 24.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START: 9:15AM Temp: 320°F FIN: 9:45AM	0.00	=> M 10/04/21			24	Ø		
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00	BR 10-4-21						
170  Packaging Packaging	Identify as per dwg & Stock Location: ST 507 Memo	0.00	= m-l 10/04/26						

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Item ID: D3910-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug

Start Date: 4/15/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/27
MF
10-4-26

Picklist Print

Page 1

Thursday, April 15, 2010 3:08:04 PM

Work Order ID: 57811



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 4/15/2010

Required Date: 4/30/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	524.7499	3.2842			



Lug Extrusion



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT06

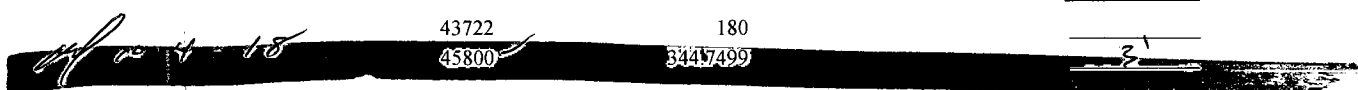
524.7499

43722

180

45800

344.7499



DART AEROSPACE LTD		Work Order: 57811
Description: TUBE LUG		Part Number: D 3910-3
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	+/- .030	4.454	/			
1.38	+/- .030	1.380	/			
2.06 - 2.10	.06 - .10	2.06	/			
.27	+/- .030	.278	/			
.31	+/- .030	.305	/			
21.20	+/- .030	21.20	/			
.735	+/- .010	.738	/			
1.41	+/- .030	1.401	/			
.100 x 45°	+/- .010	.095 x 45°	/			
.375	+/- .010	.375	/			
3.700	+/- .010	3.700	/			
.257	+ .006 - .001	.257	/			
.625	+/- .010	.625	/			
.375	+/- .010	.375	/			
2.34	+/- .030	2.34	/			

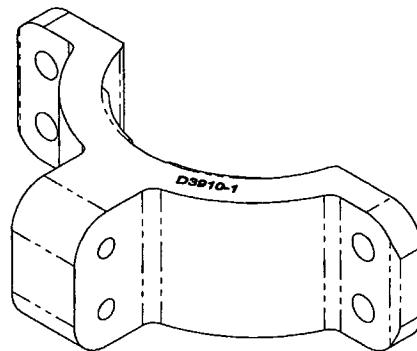
Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10.4.18	Date: 10/24/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

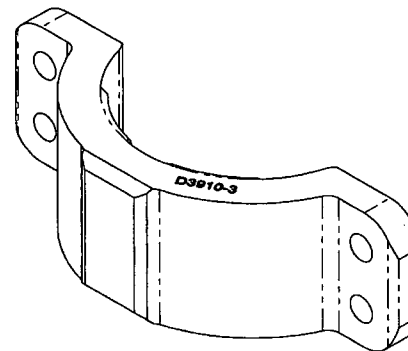


7 deadly wastes

- 1. Overproduction***
- 2. Rework***
- 3. Transportation***
- 4. Inappropriate / over Processing***
- 5. Unnecessary Inventory***
- 6. Delays / Waiting***
- 7. Unnecessary Motions***



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

#57811

RELEASED
2010-03-22
MP

NOTES:

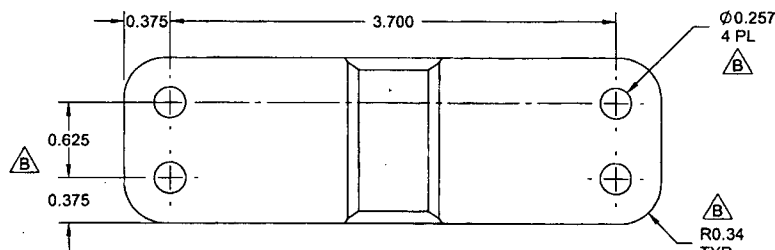
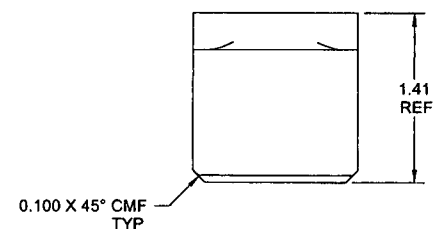
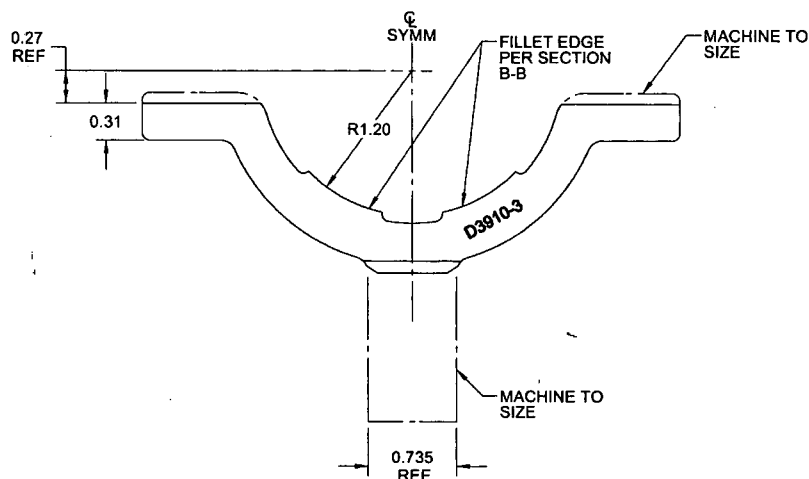
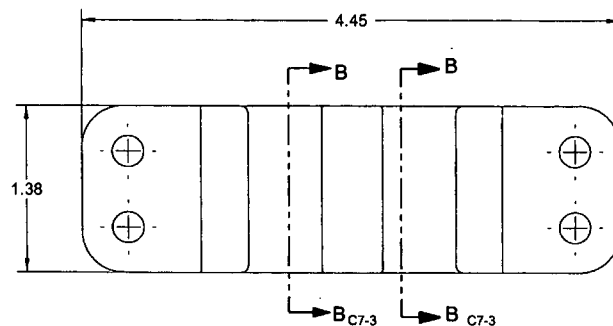
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE X-TUBE LUG (350)	SHEET 3 OF 3
APPROVED		SCALE	NTS
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DATE	10.03.16		